

Monday, September 22, 2014 2:40:15 PM

124714

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Lower Cutter Assy High

Start Date: 9/22/2014 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 9/22/2014 **Req'd Qty:** 2.00 ***C***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-09-22 Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 124714

Monday, September 22, 2014 2:40:15 PM

124714

Page 2

Item ID: 647.3804

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Cutter Assy High

Start Date: 9/22/2014 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Identify as per dwg & Stock Location: CC27

0.00

140

Packaging

Memo

0.00

IDENTIFY AS PER IAW MPP-120

2

DAS

86

4-89

JAN 05 2015

150

QC21 - Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

15/1/16 JSMSIS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, December 19, 2014 1:03:49 PM

Page 1

Work Order ID: 124714

124714

Parent Item: 647.3804

647.3804

Parent Item Name: Lower Cutter Assy High

Start Date: 9/22/14

Required Date: 9/22/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

646.9701		Manufactured	No			110	Each	5.0000	1	2			
646.9701									**				
Cutter Sub Assembly												DAS 41 9-89	14-12-19

Location	Loc Qty	Loc Code
cck009	5	
117888	1	
121152	4	

NAS1149FN832P		Purchased	No			110	Each	6,096.000	6	12			
NAS1149FN832P									**				
Washer												DAS 41 9-89	14-12-19

Location	Loc Qty	Loc Code
ST260a	3600	
125268	3600	
st268	2496	
123185	30	
M130388	2466	

MS21042L08		Purchased	No			110	Each	1,295.000	3	6			
MS21042L08									**				
Nut												DAS 41 9-89	14-12-19

Location	Loc Qty	Loc Code
CA	101	
m129682	101	
ST304	1194	
123900	16	
m128401	578	
m130325	600	

DQA: _____ Date: _____



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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, December 19, 2014 1:03:49 PM

Page 2

Work Order ID: 124714

124714

Parent Item: 647.3804

647.3804

Parent Item Name: Lower Cutter Assy High

Start Date: 9/22/14

Required Date: 9/22/14

Start Qty: 2.00

Required Qty: 2.00

MS27039-08-19

Purchased

No

110

Each

486.0000

3

6

DAS

41

9-89

14-12-19

MS27039-08-19

Screw

Location

Loc Qty

Loc Code

ST273A

486

m130505

486

6

647.3902

Manufactured

No

110

Each

15.0000

1

2

DAS

41

9-89

14-12-19

647.3902

Lower Deflector Assembly, High

Location

Loc Qty

Loc Code

cck053

15

124694

15

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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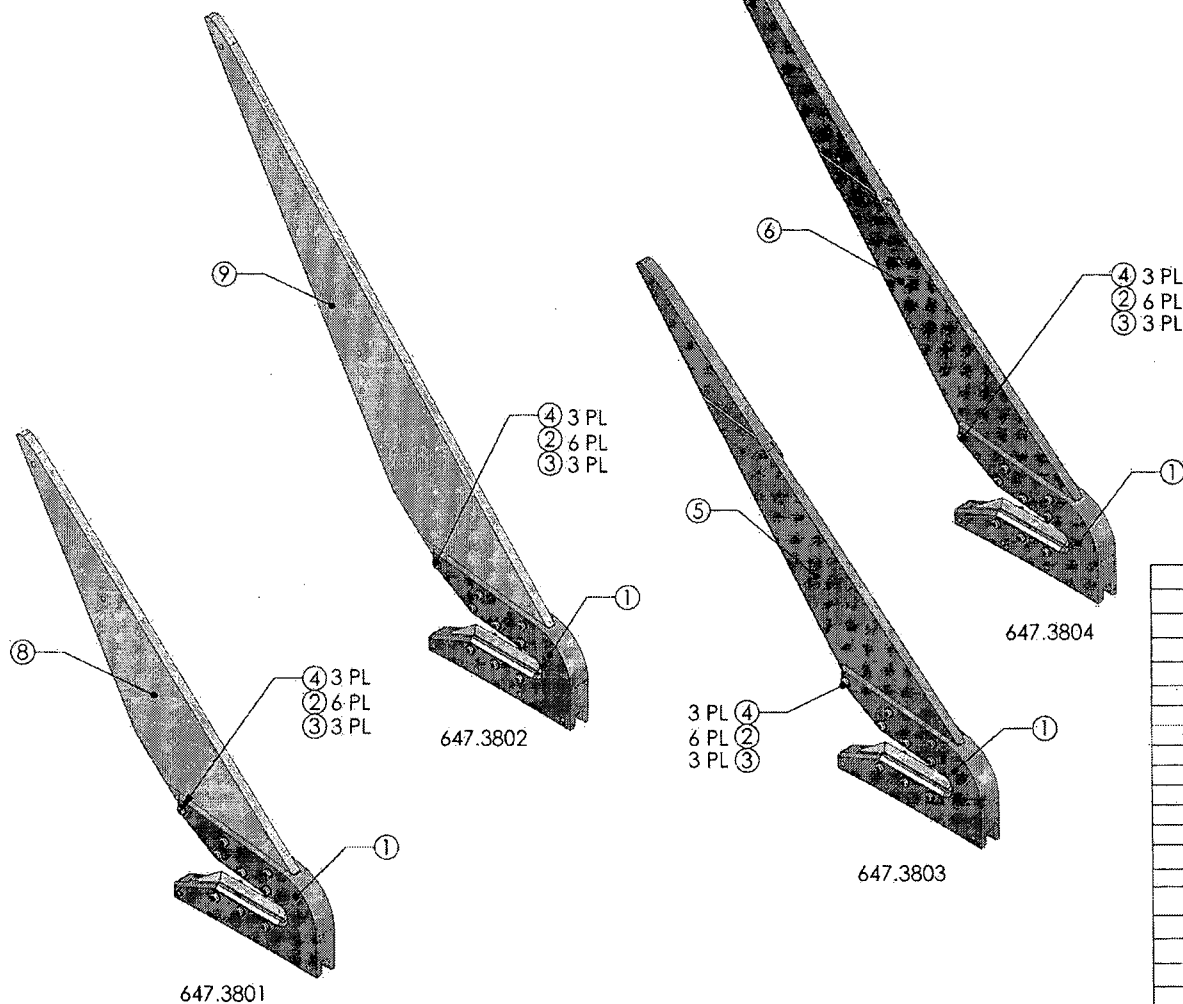
NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PP1		JUC
121C	INITIAL RELEASE	09-08-09	P. EDWARDS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124714 M C

14-09-22



		I		9	647.3911	212 UPPER DEFLECTOR		
			I	8	647.3910	412 UPPER DEFLECTOR		
A/R	A/R	A/R	A/R	7	601.2045	RTV. LOCITE 598		
I				6	647.3902	LOWER DEFLECTOR ASSY HIGH		
	I			5	647.3901	LOWER DEFLECTOR ASSY LOW		
3	3	3	3	4	601.2765	SCREW	M52703P-0819	
3	3	3	3	3	601.1541	LOCKNUT	N52104X206	
6	6	6	6	2	601.2764	WASHER	F4S1149FNB32P	
I	I	I	I	I	646.9701	CUTTER SUB ASSY		
X	X	X			647.3804	LOWER CUTTER ASSY HIGH		
X	X	X			647.3803	LOWER CUTTER ASSY LOW		
X	X	X			647.3802	212 UPPER CUTTER ASSY		
X	X	X	X		647.3801	412 UPPER CUTTER ASSY		
.3804	.3803	.3802	.3801	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY								
NEXT QUOTE (\$)				PART LIST				
647.3700				APICAL INDUSTRIES				
				2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-S3				
				CUTTER ASSY				
				JHE QUA CODE# DWYS YTD B D/M/A/E 647.3800				
				SCALE INCHES SHEET C/FI				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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